

ment to locate any number of holes in the work in the desired relation to each other, as the table slides may be manipulated and final settings made with the micrometer heads and distance bars, so that each hole is located in the proper relation to the preceding hole. Clamps are provided to lock the table in each position before the drilling operation is started.

The distance bars are supported by bushings held in V-shaped seats, which support them at the proper height to line up properly between the micrometer spindles and stops on the table which come in contact with the micrometer spindles

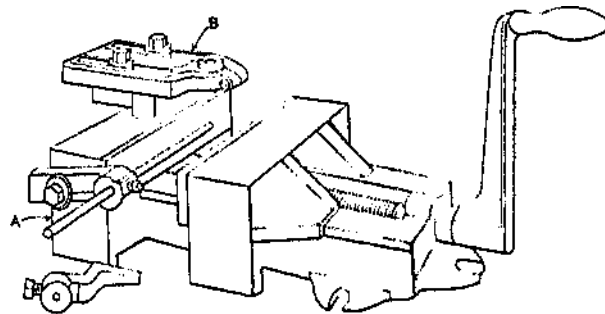


Fig. 28. Vise **with** Jig Attachment

when the table is set in the zero position. Johansson or other gages may be used in place of the distance bars, if so desired.

Jig Attachments for Drilling in Vises, ~- The machine vises such as are used for milling or planing operations may be used for drilling when they are provided with attachments for holding drill bushings or

locating stops. There are now on the market vises furnished with jig attachments ready for use. One of these vises is illustrated in Fig. 28, where it will be seen that a stop *A* may be used to locate the work while the bracket *B* holds the bushing which guides the drill.

As a simple illustration of the principle involved in using a jig of this type, reference is made to Fig. 20, in which the part being machined is a round collar. The collar *A* is gripped against a vee in the solid jaw, and the bracket containing the